

Date: Tuesday, 16/01/2007 9:57:01 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STIFFNER
Job Number : 30288	
Estimate Number : 12642	
P.O. Number : N/A	Part Number : G106046
This Issue : 16/01/2007 S.O. No. : N/A	Drawing Number : G10604 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 26/01/2007 Qty: 10 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 07-01-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
Comment: Qty.: 0.2615 sf(s)/Unit Total : 2.6145 sf(s) 2024-T3 .050 sheet *****Grain must Run Along 8.59" Dim ***** Batch: <u>m103210</u> - <u>ml 07 01 16</u> (10)		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg G10604 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary *****Use same cutting file for -3 & -6 ***** <u>ml 07 01 16</u> (10) <u>SP am 07 01 18</u> (10)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 07 01 16</u> (10)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>ml 07 01 16</u> (10)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: He Date: 07/18/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/01/2007 9:57:01 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STIFFNER

Job Number: 30288

Part Number: G106046

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'SINK AS PER DWG G10604,

****NOTE:-3 & -6 ARE C'SINKED ON OPPOSITE SIDES****

2-FORM AS PER DWG G10604

FP 07-01-19

SP 07/01/19

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DA 07/01/19 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SS 1 07/01/22 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/22 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/01/22 (10) 07/01/22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/22 (10)

Job Completion



U 07/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

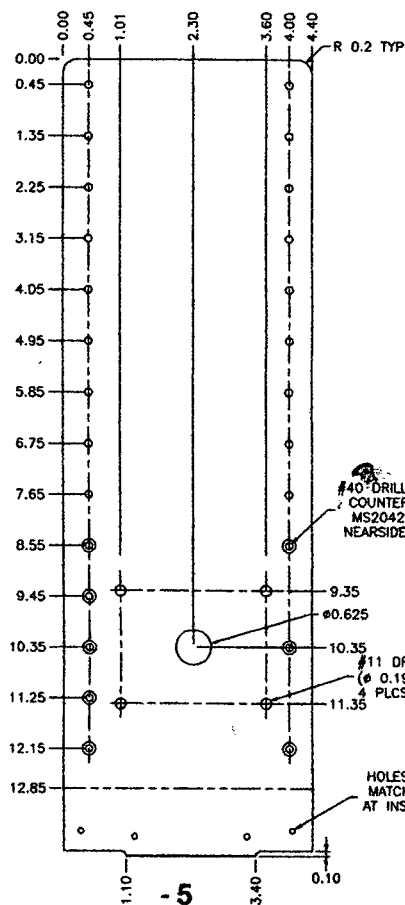
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

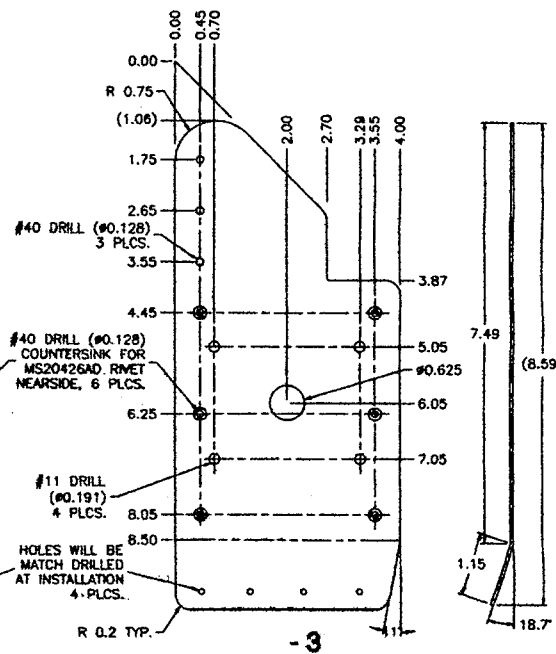
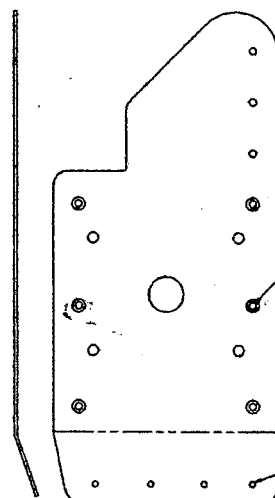
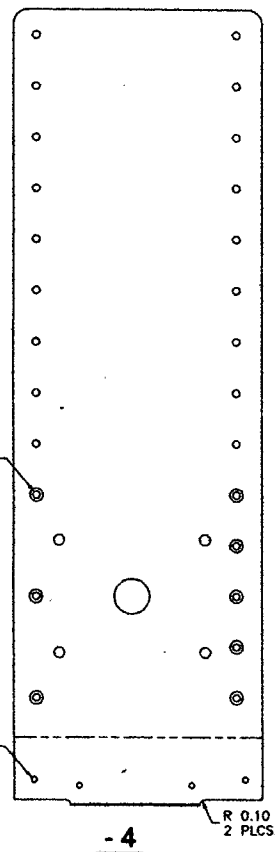
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NCR Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REV	REVISION		DATE	APPROV.
	DESCRIPTION			
A	- COMBINE SHEET 1 AND 2. - CHANGE DRAWING FORMAT. - UPDATE DIMENSIONS AND NOTES. - ECO 1038, 1040		4/9/01	



-4 AND -5 FLAT PATTERN ARE IDENTICAL
EXCEPT BENDS ARE OPPOSITE SIDE
AND COUNTERSINK AS NOTED



-3 AND -6 FLAT PATTERN ARE IDENTICAL
EXCEPT BENDS ARE OPPOSITE SIDE
AND COUNTERSINK AS NOTED

NOTES:

UNLESS OTHERWISE NOTED.

- MAT'L: ALUM 0.050 THICK. 2024-T3
QQA-250/4
- ALL PILOT HOLES ARE #40 DRILL (#0.098),
TO BE DRILLED TO SIZE AT ASSEMBLY.
- FINISH: ETCH, ALODINE PER MIL C5541-1A,

BREAK ALL EDGES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONAL TOLERANCES 3 DECIMALS ± 0.010 2 DECIMALS ± 0.008 1 DECIMAL ± 0.004 ANGULAR ± 1°		DRAWN T. S. DATE 3/20/95	CHECK DATE DATE DATE	DESIGN DATE DATE DATE	APPROVAL RCC DATE 4/3/95	THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR REPRODUCED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.	GENEVA AVIATION 10108 - 32nd Ave W Everett, WA 98204 (425)353-7400 FAX(425)347-7100
		TITLE REAR SHOULDER HARNESS STIFFENER		PART NO. G10604		REV A	
		SIZE D		SCALE 1/1		SHEET 1 OF 1	

DART AEROSPACE LTD	Work Order:	30288
Description: ST. H. Ner	Part Number:	G106046
Inspection Dwg: DG10604, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
-------------------------------------	---------------	-------------------------------------	-----------

[illegible]

Measured by:	<i>ML: ML</i>	Audited by:	<i>ML</i>	Prototype Approval:	<i>N/A</i>
Date:	<i>07/01/16</i>	Date:	<i>07/01/16</i>	Date:	<i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

12/1/78

SHIP TO: DATE: 12/12/07 RECEIVED: 12/12/07
SOLD TO: DATE: 12/12/07 RECEIVED: 12/12/07

**KAISER
ALUMINUM**
Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4062914

CUSTOMER PO NUMBER: N18187	WORK PACKAGE:	CUSTOMER PART NUMBER:	SHIP UNLOAD ID: 100880/10	GOVT CONTRACT NUMBER:
KAISER ORDER NO: 1033882	LINE ITEM: 1	SHIP DATE: 24-MAR-2008	ALLOY: 2024	CLAD: CLAD
WEIGHT SHIPPED: 7885 LB	QUANTITY: 223 PCS EST.	M/L NUMBER: 207855	GAUGE: 0.0500 IN	TEMPER: T3
			WIDTH: 48.000 IN	LENGTH: 1-4.000 IN

Certified Specifications

AMS 4041/RevP
BATS 2505/RevNC

AMS QQ-A-2805/RevA
DMS 2174/RevB

ASTM B 209/Rev04

Test Code: 4013

Lot: 350042A8 Cast 918

Drop 16

Ingot 2

Tensile:	Temper T3	Dir / # Tests LT / 2 (Min:Max)	Ultimate KSI (MPA) 63.9 : 64.7 (441 : 445)	Yield KSI (MPA) 44.8 : 45.8 (309 : 318)	Elongation % 15.2 : 13.8
----------	--------------	-----------------------------------	--	---	-----------------------------

MPS Deflection: 0.017 IN

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.24	4.57	0.59	1.40	0.01	0.13	0.02	0.01	0.01	TOT 0.04

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.06
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15
LINER MIN	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	EACH	0.03
MAX	0.25	0.40	0.05	0.05	0.05	0.00	0.05	0.03	0.05	0.00	TOT	0.00

Aluminum Remainder

TEST NOTES

MATERIAL MEETS MINIMUM RESIDUAL STRESS (MRS) CHEMICAL
MILLING QUALITY (CMQ) REQUIREMENTS.

